

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029049**Date Inspected:** 25-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** USA Hoist, Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** SAS Tower Elevator**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At USA Hoist assembly shop, this QA randomly observed USA certified welder Matt Wasiqi continuing to perform 1G (flat) position gas shielded Flux Cored Arc Welding (FCAW-G) welding Complete Joint Penetration (CJP) between C-channels C200 x 20.5/C180 x 18.2 x 2500mm long part numbers 914931/914925 and angular 6.4 x 6.4 x 9.5 x 1800mm long part number 914900-02. The C200 x 20.5 channel is being welded on the left side of the 6.4 x 6.4 angular while the C180 x 18.2 channel is being welded on the right side. These channels to angle connections are intended for door enclosure frame for elevator stops at 2 (elevation 53.85 meter), stop 3 (elevation 89.85 meter) and stop 6 (elevation 156.80 meter). During the shift, another USA Hoist welder Genaro Ulloa who is also the shop foreman was noted giving instructions to welder Matt Wasiqi and at the same time performing back gouging the other side of the CJP joints of the connections being welded. After welder Matt Wasiqi has completed welding the CJP joints for the door enclosure frame for the elevator stops 2, 3 and 6, the welder started CJP welding the same enclosure for elevator stops 1, 4 and 5. These three enclosure frames have the same shape and materials used in elevator stops 2, 3 and 6. The only difference noted was in length of the two C channels wherein the measurement was 2106mm long. The C-channels C200 x 20.5/C180 x 18.2 x 2106mm long were marked part numbers 914930/914911 and angular 6.4 x 6.4 x 9.5 x 1800mm long was marked part number 914900-02. The C200 x 20.5 channel is being welded on the left side of the 6.4 x 6.4 angular while the C180 x 18.2 channel is being welded on the right side. At the end of the shift, two enclosure frames for the elevator stops 2, 3 and 6 were completed and one enclosure frame for elevator stops 1, 4 and 5 was completed.

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This QA was invited to attend the Construction Meeting between USA Hoist, Caltrans and ABF. Before the meeting, this QA met with Caltrans personnel Mr. Bill Casey Project Resident Engineer, Mr. Gary Thomas SMR, and Mr. Martin Chandrawinata Design. During the meeting, various aspects of the project were discussed but one particular that QA was involved was in the change of an approved weld joint design. Mr. Tim Moran had the impression that since USA Hoist is the designer and manufacturer of the elevator, USA Hoist could change the weld joint design by just informing QA on the shop then mark the item on the drawing. This notion was contradicted by Mr. Bill Casey and that he informed Mr. Tim Moran that such weld design changes require approval from Caltrans. The meeting started at around 0945 hours and was adjourned at around 1220 hours.



Summary of Conversations:

This QA was requested to attend the Construction Meeting between Caltrans, ABF and USA Hoist. Various topics were discussed during the meeting that include the design changes to approved drawings.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer